

Work Order ID 50585

July 16, 2009 9:54:50 AM



Page 1

Item ID: D350-591-311

Accept



Setup Start



Revision ID: B

Item Name: Heli-Access-Step, Long LH

Stop



Start Date: 07/16/2009 Start Qty: 1.00

Required Date: 07/20/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference: custom.

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY 12-Weld Support using Jig DT8719, weld
Fwd End Plate as per QSI 004 & Dwg D327211A/ALuminum
Rod 13-Grind End Plate flush

120

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

See last page

Closed at

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50585

July 16, 2009 9:54:50 AM



Page 2

Item ID: D350-591-311

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 07/16/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/20/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

140



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

150



QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50585

July 16, 2009 9:54:50 AM



Page 3

Item ID: D350-591-311

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 07/16/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/20/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Assemble Leg Assembly as per Dwg D3272. Leave one rivet out until welding is complete.								
170		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
180		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Bevel Aft end for welding 12-Inspect for foreign object as per QSI 024 13-Weld Aft End Plate as per QSI 004 & Dwg D3272 14-Grind End Plate flush 15-Install last rivet as per Dwg.								

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50585

July 16, 2009 9:54:50 AM



Page 4

Item ID: D350-591-311

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 07/16/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/20/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50585

July 16, 2009 9:54:50 AM



Page 5

Item ID: D350-591-311

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 07/16/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/20/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: _____ OVEN TEMPERATURE:

FINISH TIME: _____

230

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

240

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50585

July 16, 2009 9:54:50 AM



Page 6

Item ID: D350-591-311

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 07/16/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/20/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-591-
31111Location: _____

Work Order ID 50585

July 16, 2009 9:54:50 AM



Page 7

Item ID: D350-591-311

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 07/16/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/20/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

mf 09-07-24

Location/Lot Activity

July 24, 2009 7:30:56 AM

Page 1 of 1

Criteria : All Items All Locations Lot: 44131 All Transaction Types All Dates Report on Locations & Lots

Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date	Extended Cost
Inv Adjustment	D350-591-311RevB / Heli- Access-Step, Long LH	Main Warehouse FG	go live discrepancies	FAUT01		12.0000		2.0000		
					07/24/2009	1.0000	44131	1.0000		\$497.14
								1.0000		\$497.14
Rework	D350-591-311RevB / Heli- Access-Step, Long LH	Main Warehouse FG	50585	FAUT01		13.0000		3.0000		
					07/16/2009	-1.0000	44131	-1.0000		-\$497.14
								-1.0000		-\$497.14
Shipment	D350-591-311RevB / Heli- Access-Step, Long LH	Main Warehouse FG	SO100208	BEDF01		14.0000		4.0000		
					07/13/2009	-1.0000	44131	-1.0000		-\$497.14
								-1.0000		-\$497.14